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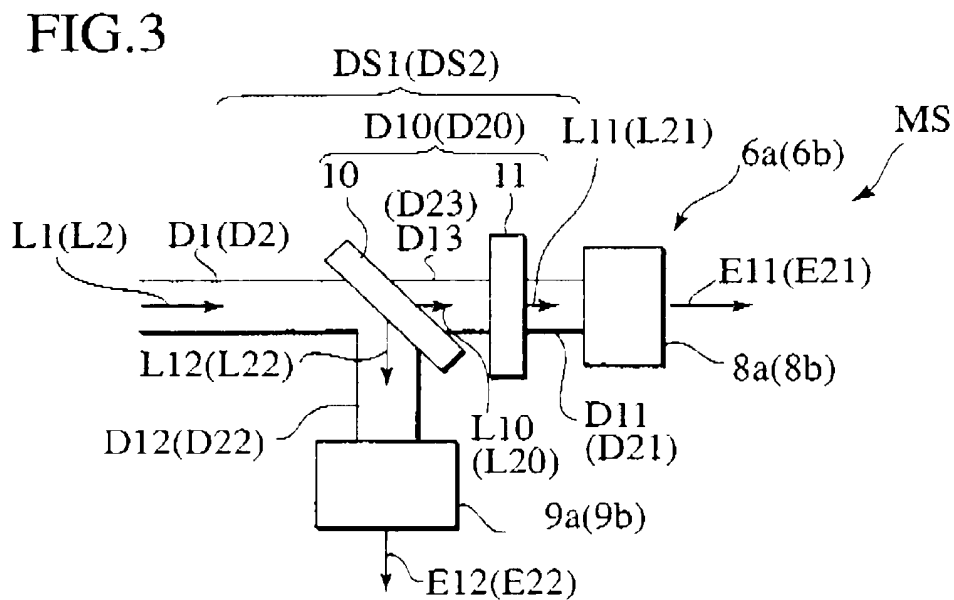
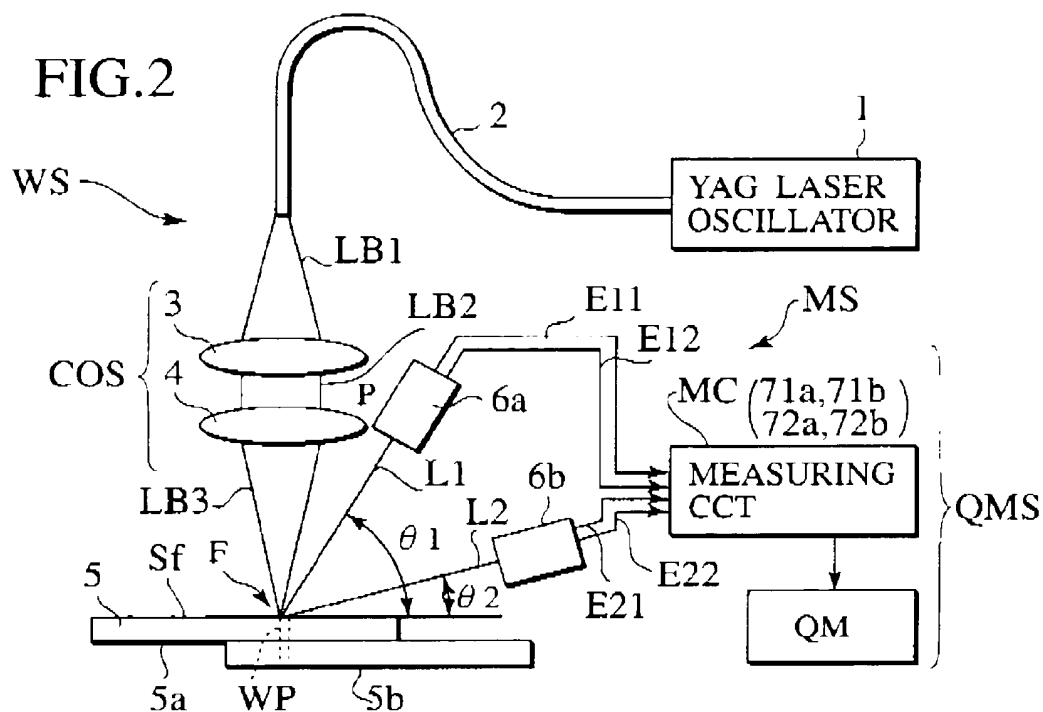
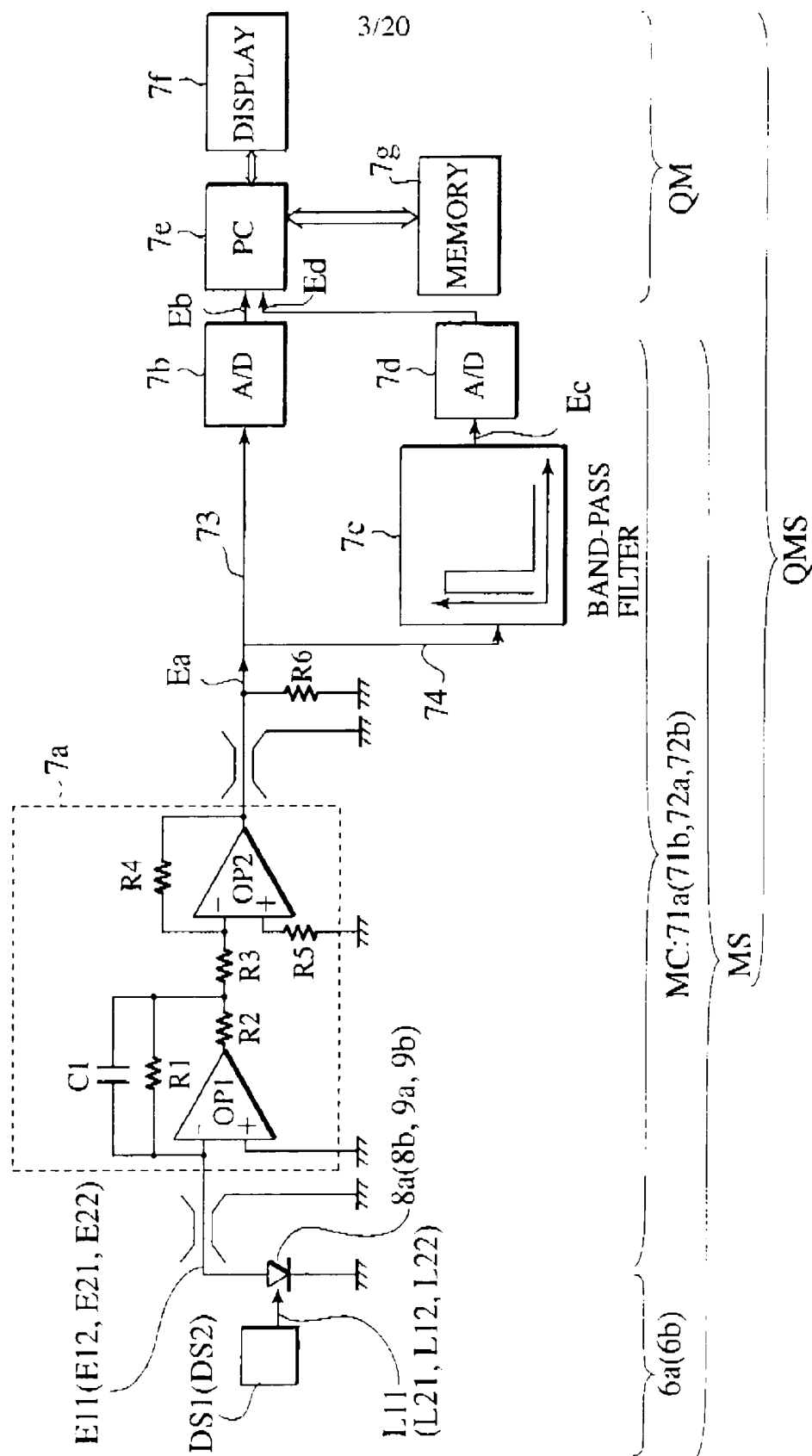


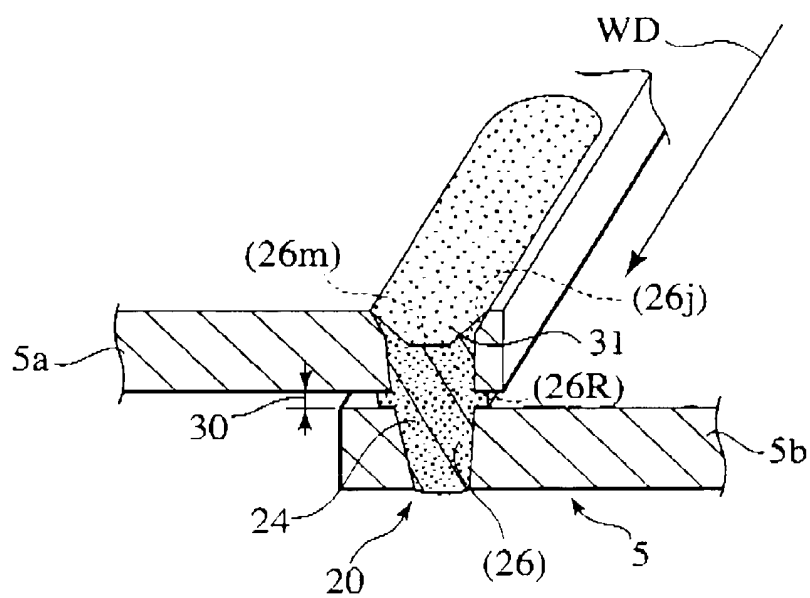
FIG.4

PL:PL1a(PL1b,PL2aPL2b)



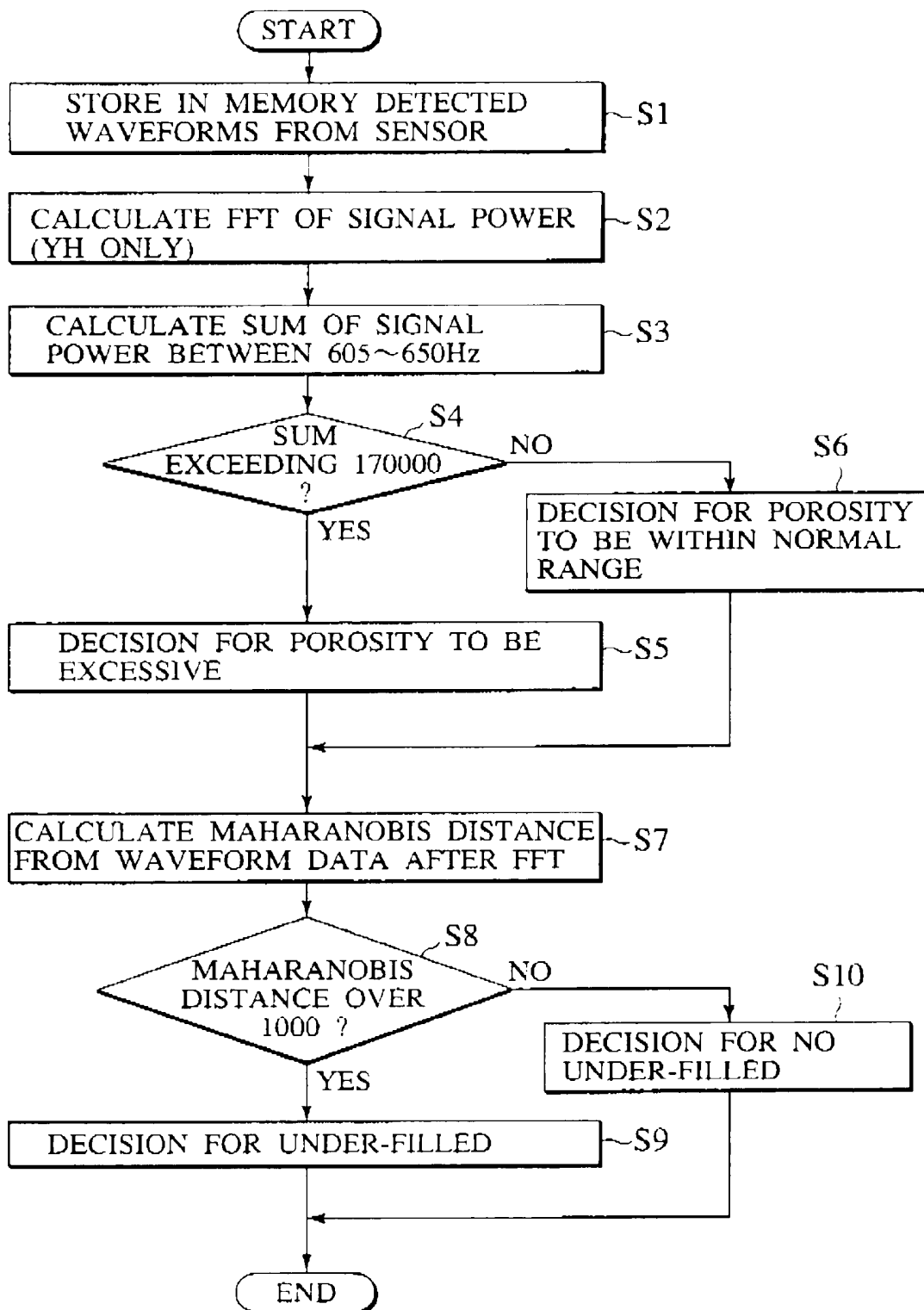
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FIG.7



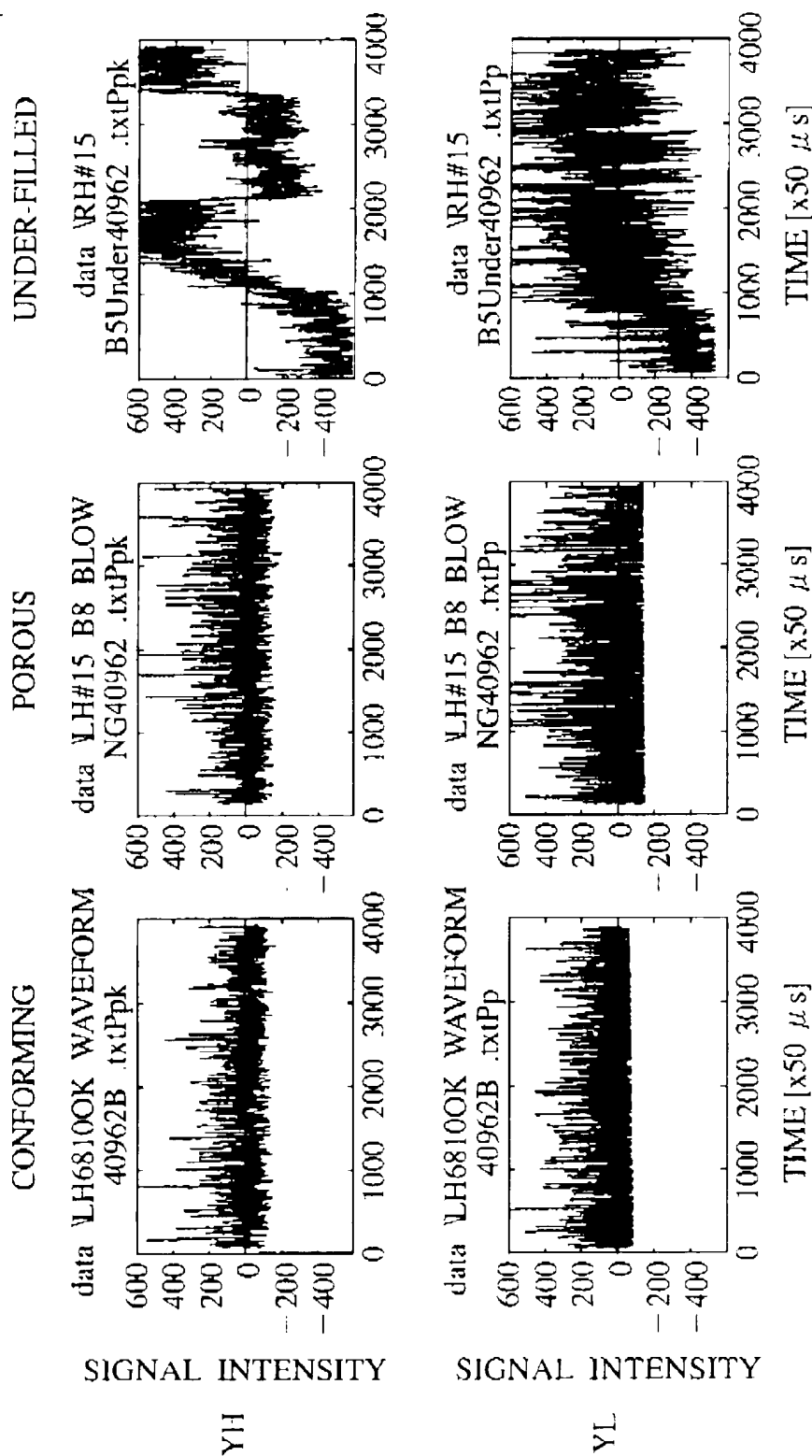
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FIG.8



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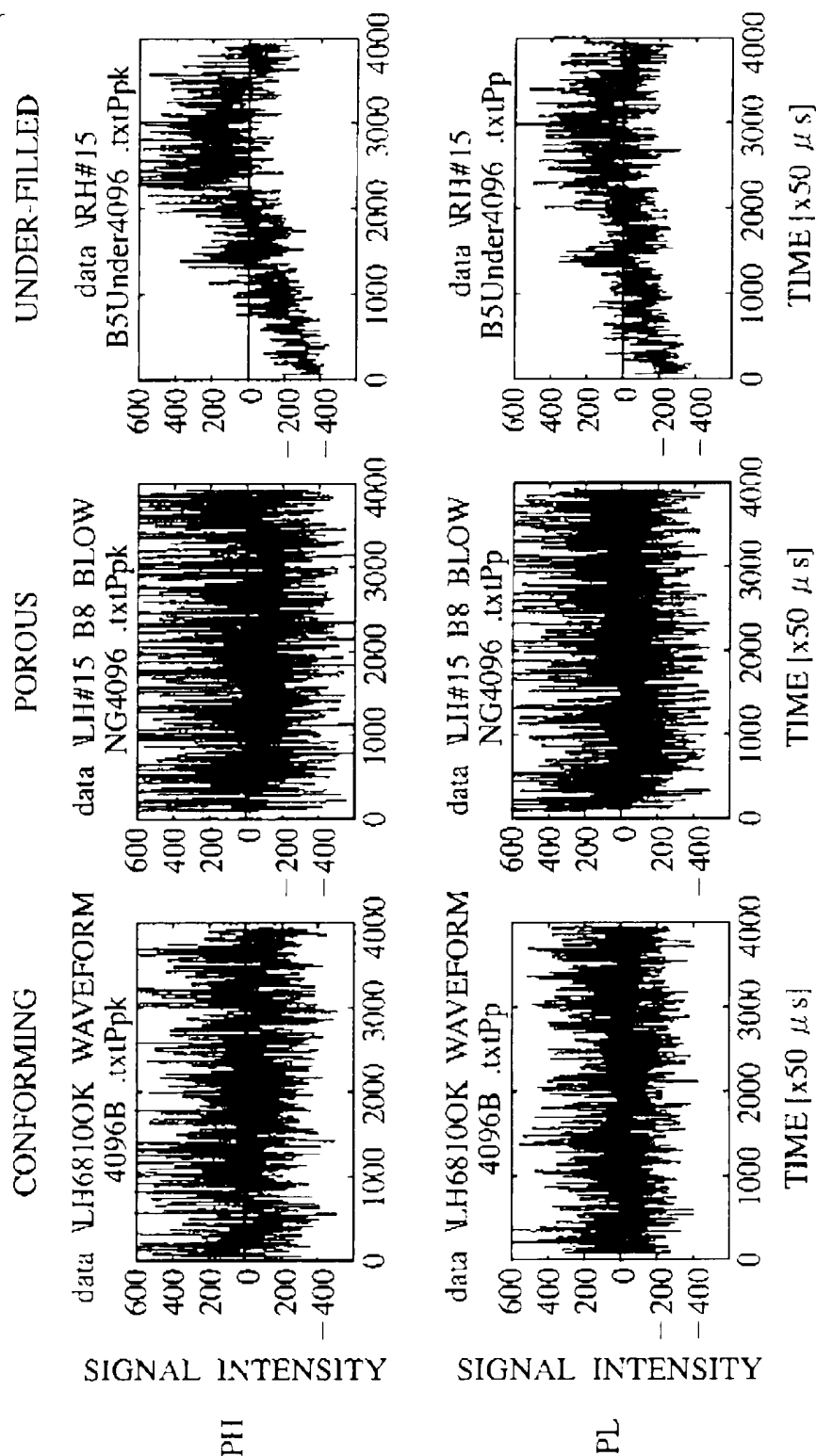
FIG.9



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

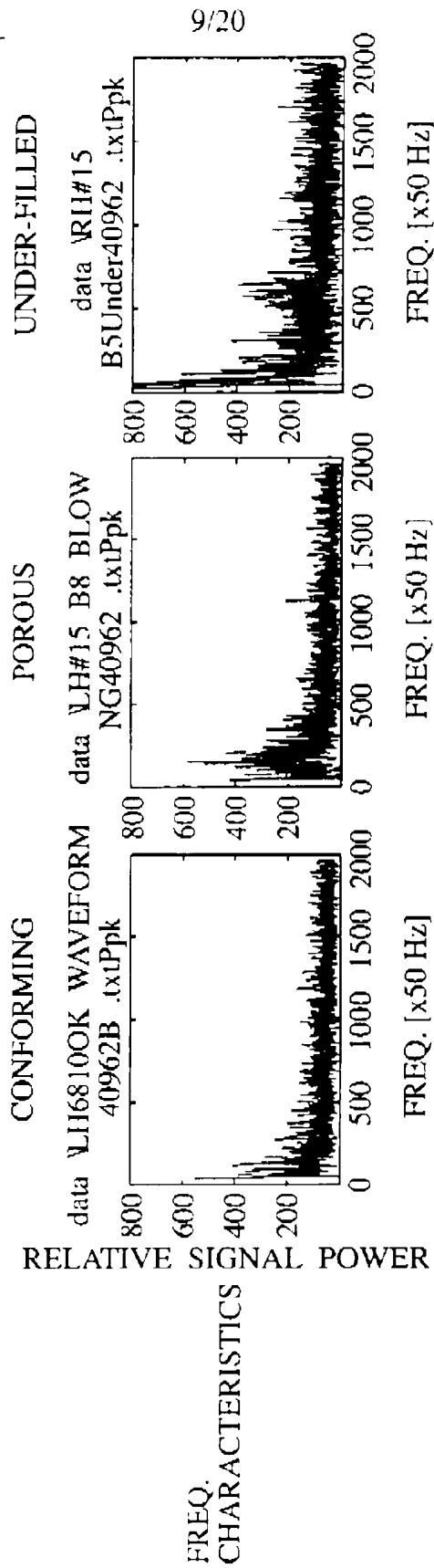
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FIG.10



DETECTED WAVEFORMS UNDER BASIC WELDING CONDITIONS

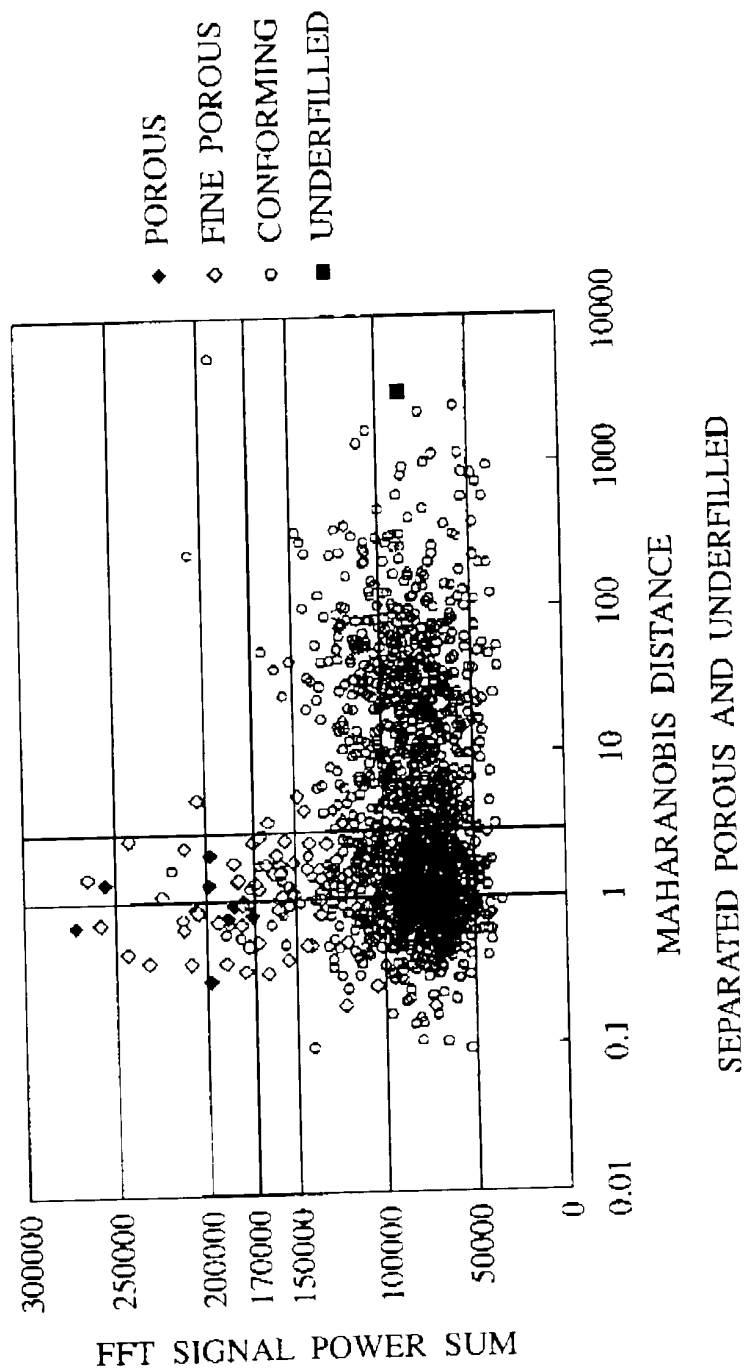
FIG.11



FREQ. CHARACTERISTICS OF YH

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FIG.12



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FIG.13

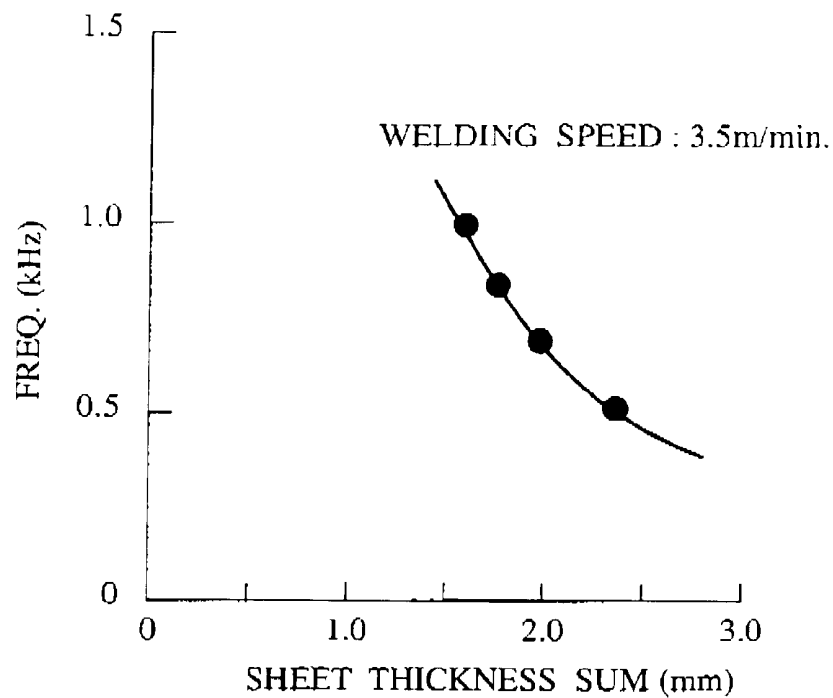
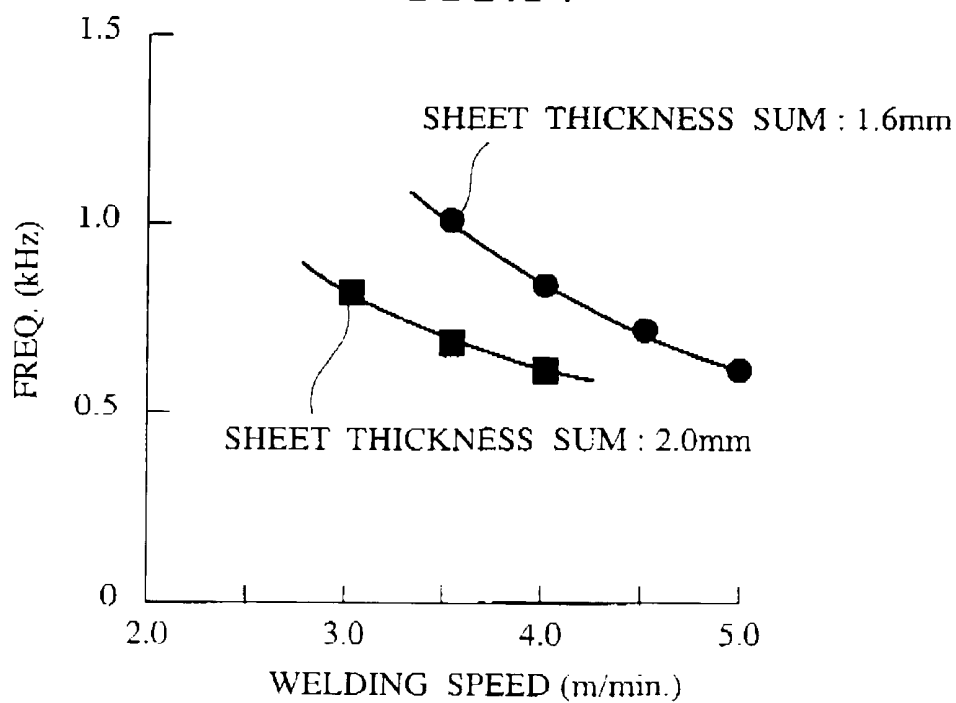


FIG.14



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FIG.15

TABLE-1

		UPPER SHEET t_1			
		LOWER/UPPER	0.8mm	1.0mm	1.2mm
LOWER SHEET t_2	0.8mm	3.5m/min.	3.5m/min.	3.5m/min.	
	"	4.0m/min.			
	"	4.5m/min.			
	"	5.0m/min.			
	1.0mm	3.5m/min.			
	1.2mm	3.0m/min.			
	"	3.5m/min.		3.5m/min.	
	"	4.0m/min.			

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FIG.16

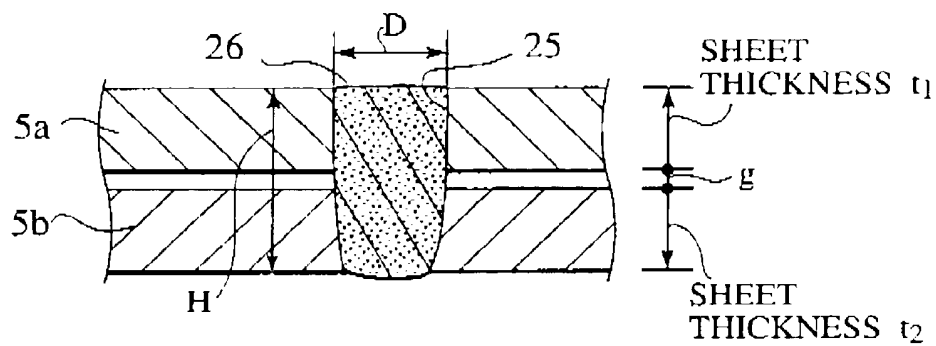


FIG.17

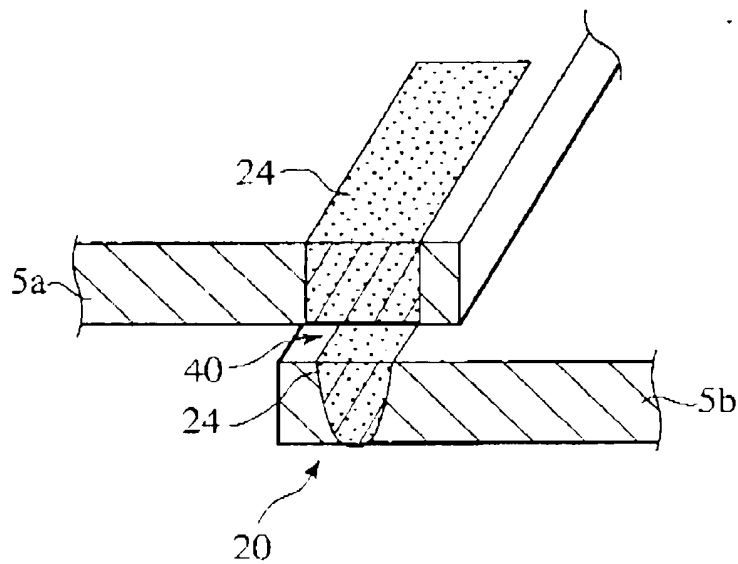
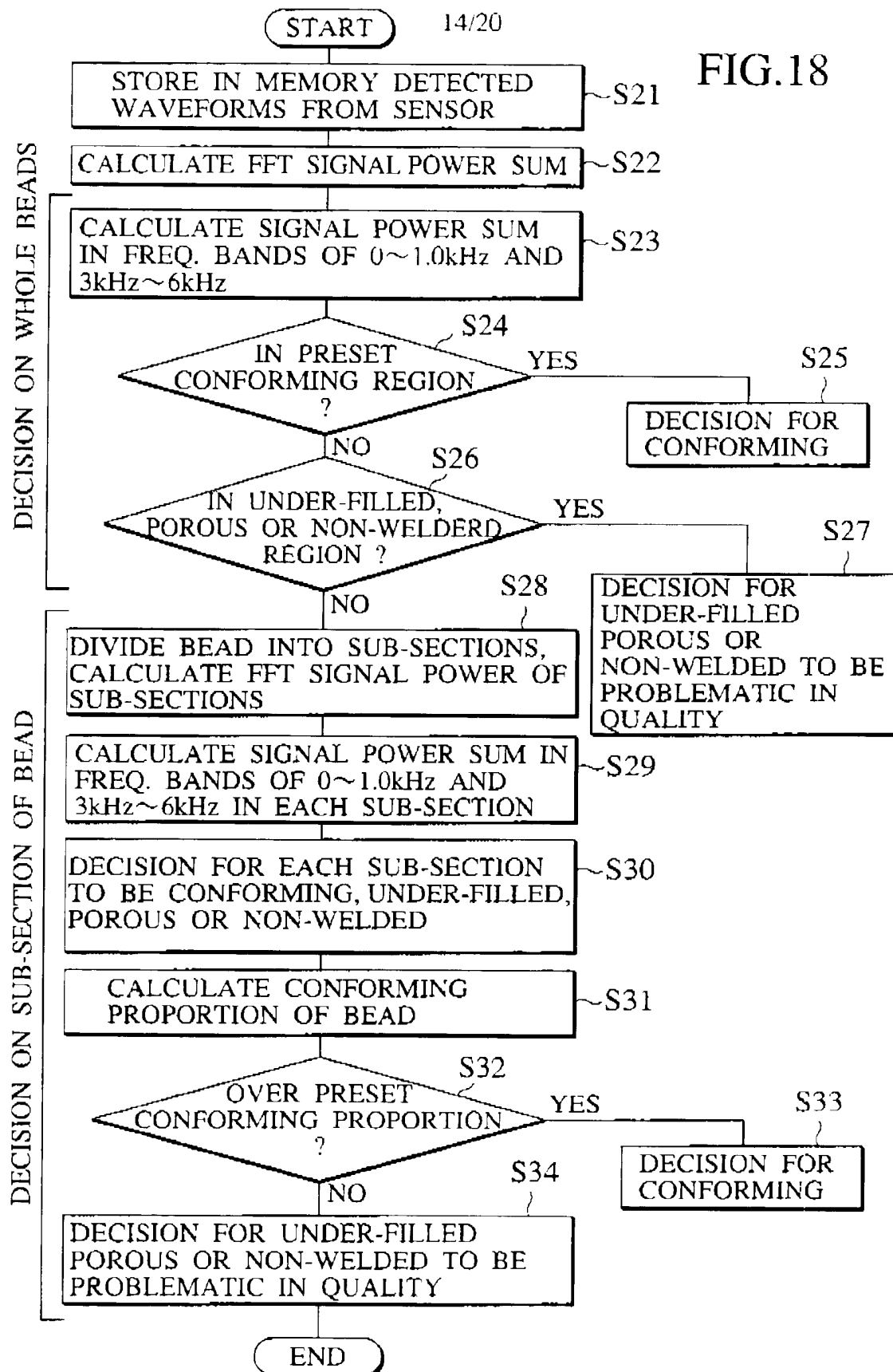
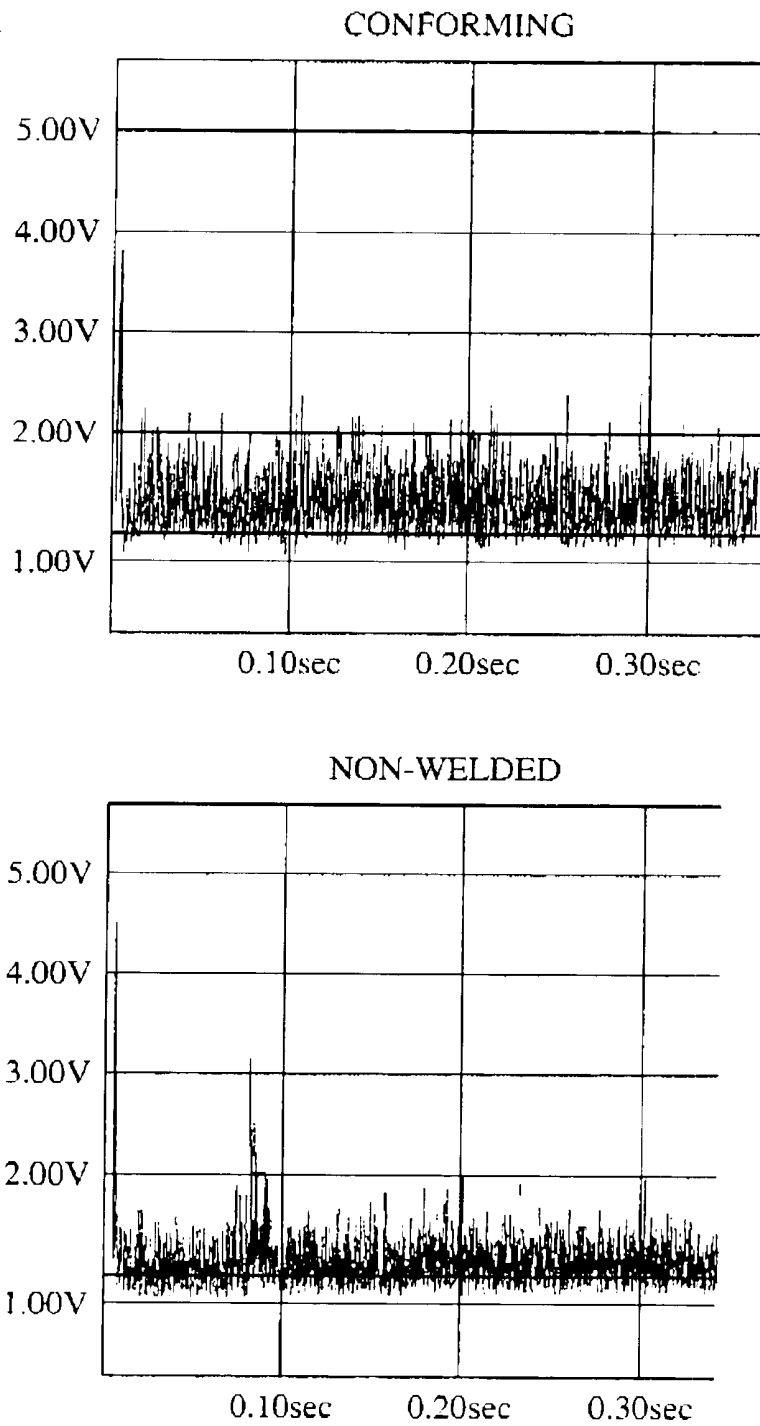


FIG.18



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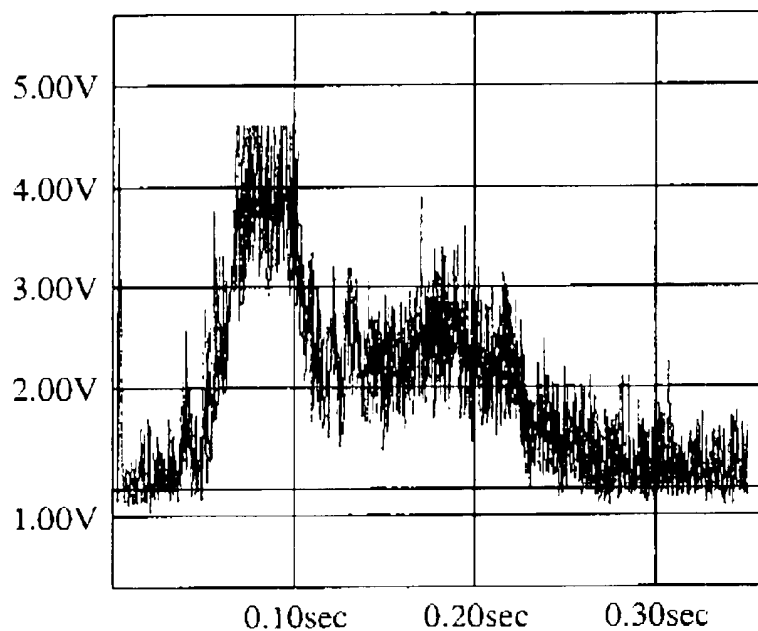
FIG.19



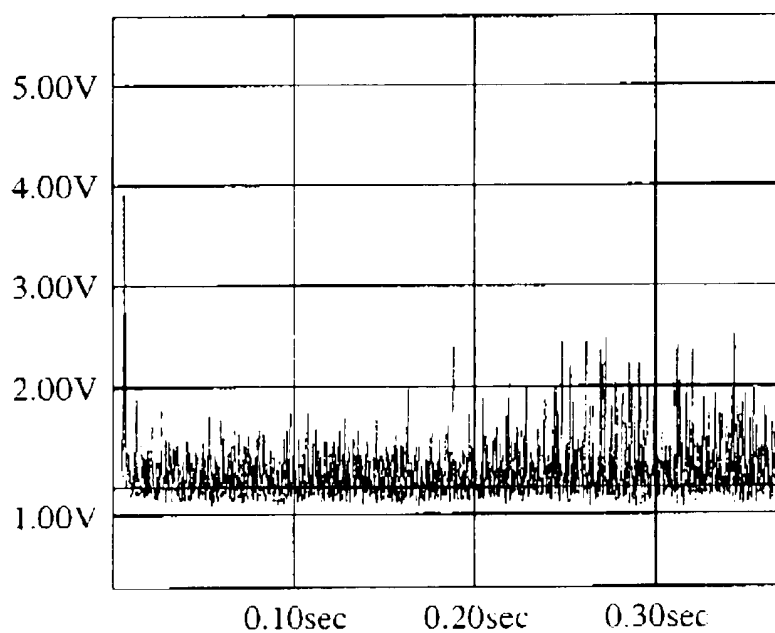
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FIG.20

UNDER-FILLED

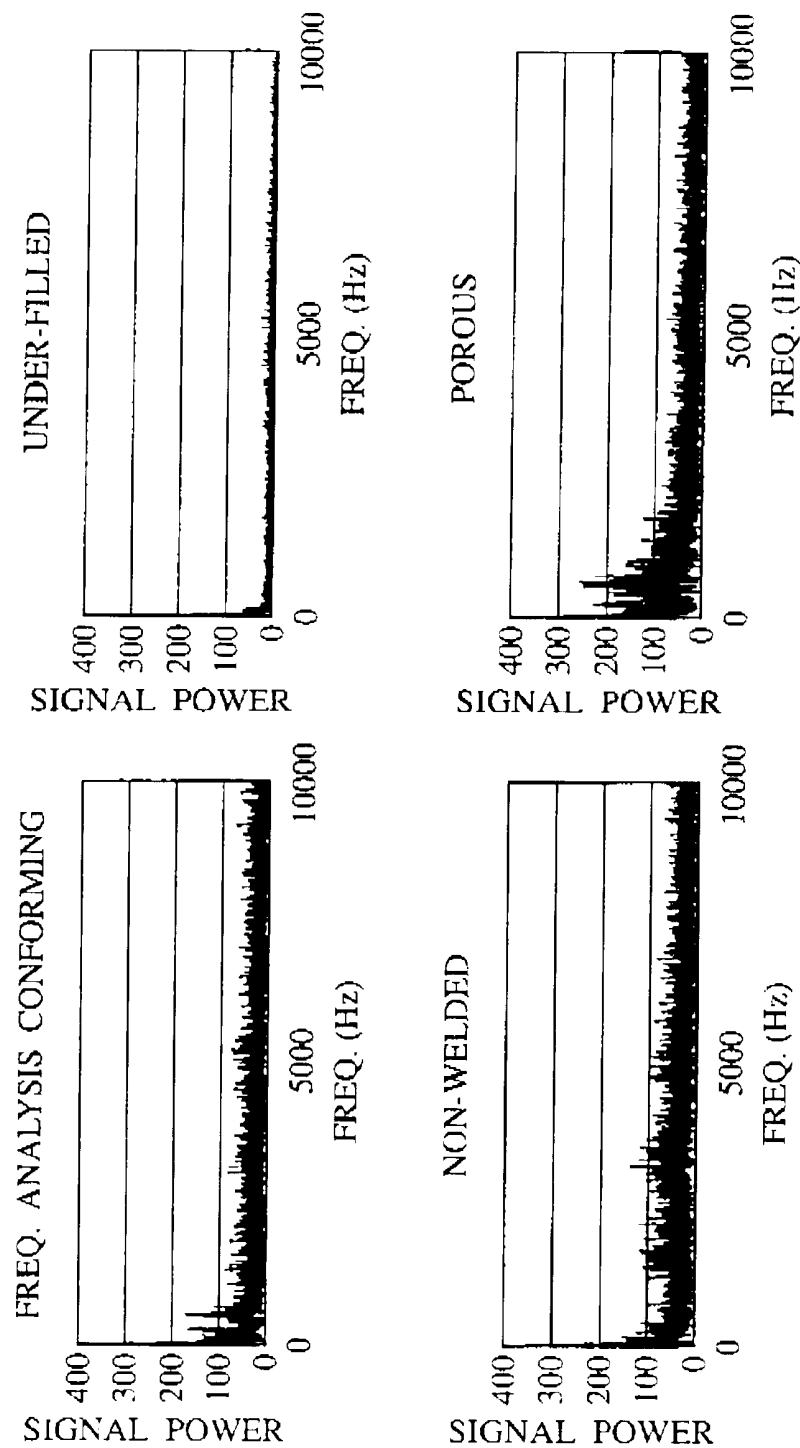


POROUS



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FIG.21



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FIG.22

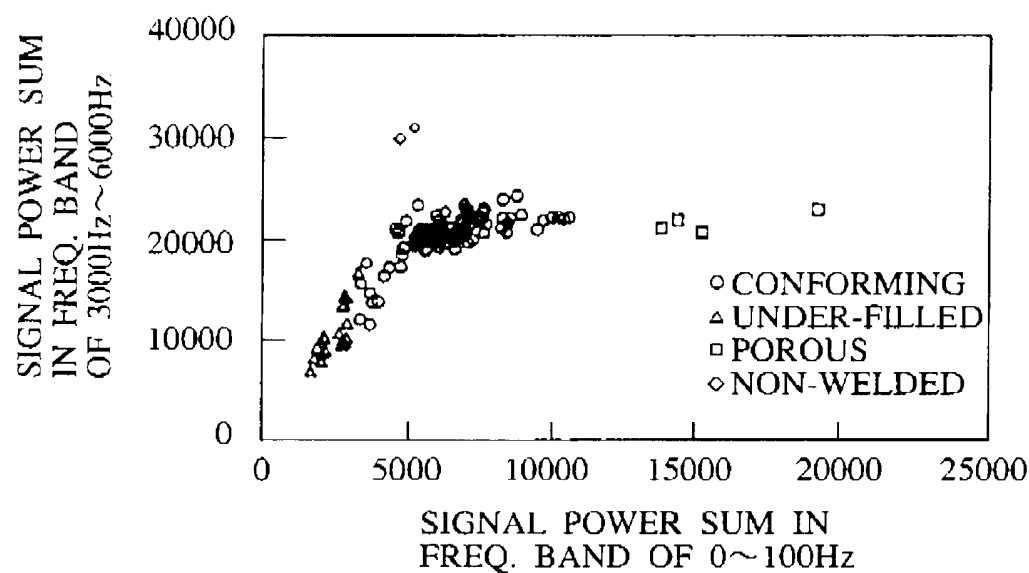
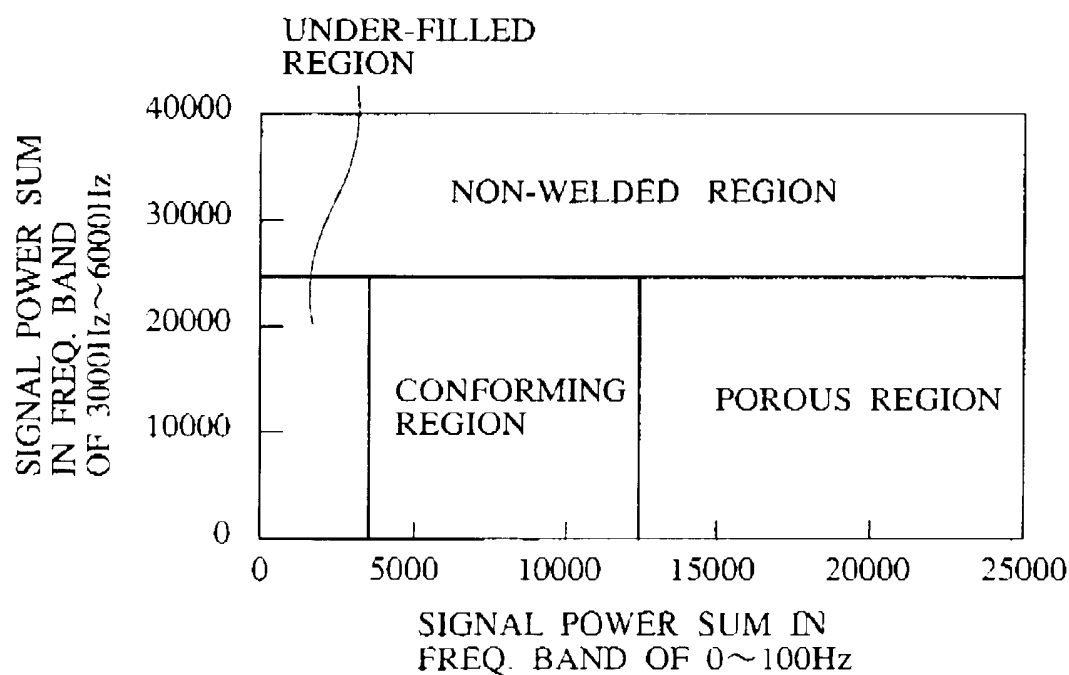


FIG.23



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FIG.24

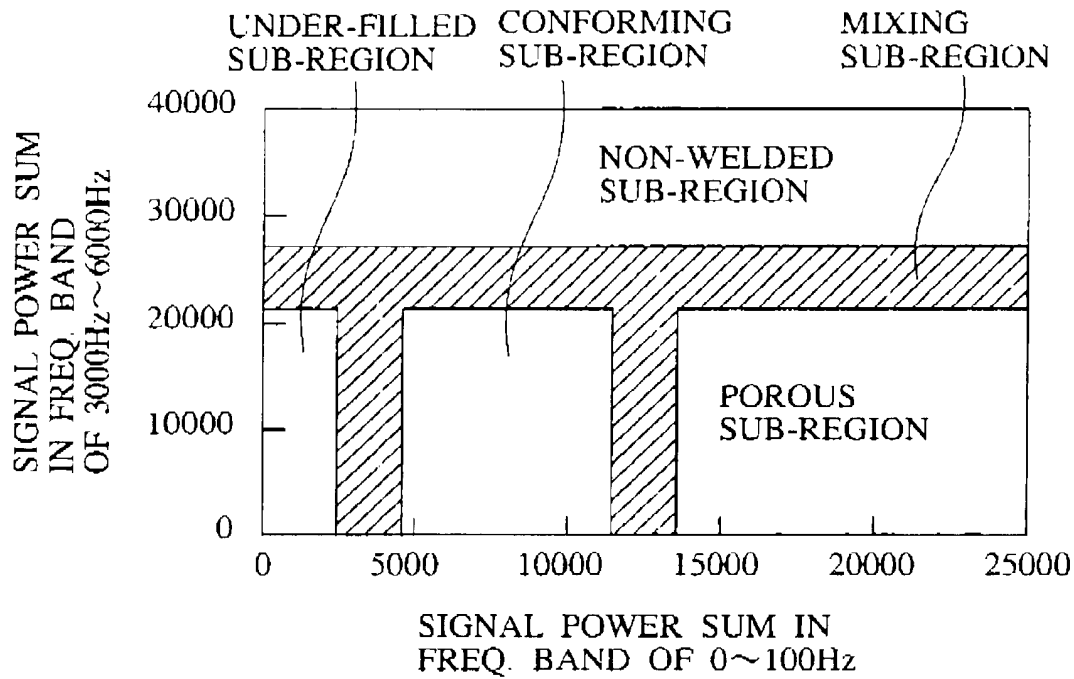
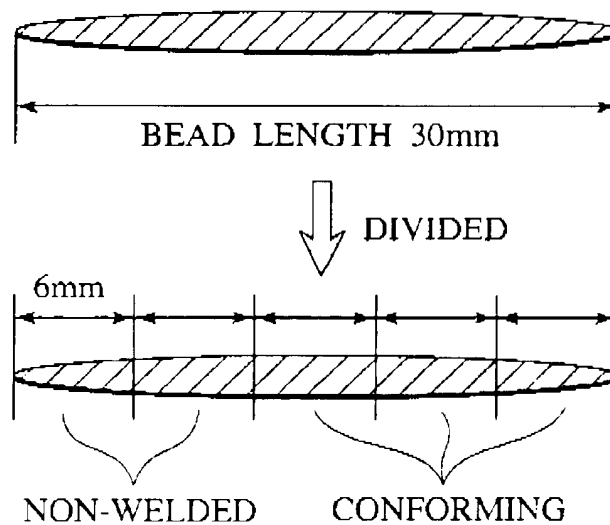


FIG.25



$$\text{CONFORMING PROPORTION} = \frac{\text{CONFORMING LENGTH 6mm} \times 3 \text{ SUB-SECTIONS}}{\text{TOTAL WELD LENGTH 30mm}} = 0.6$$

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FIG.26

